

Work Order ID 80022

Thursday, February 09, 2012 8:11:21 AM

80022

Page 1

Item ID: D4006-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Angle

Stop *NS2*

Start Date: 2/10/2012 Start Qty: 8.00

8

Cust Item ID:

Required Date: 2/17/2012 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals: Process Plan: *mf*

Date: *12-02-09* Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr Revision Nbr

D4006 A

100

0.00

100

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg

7034.063

Dwg Rev: *A*
Prog Rev: *A*

2-Deburr if necessary

B12-2-10

(12)

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

B12-2-10

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Page 2

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N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Angle

Start Date: 2/10/2012 Start Qty: 8.00 ***8***

Cust Item ID:

Required Date: 2/17/2012 Req'd Qty: 8.00 ***8***

Customer:

Reference:

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run Start
	QC:	Date:	SPC (Y/N):	Date:	Stop
					NR1
					NR2

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

130

Bend as per dwg

0.00

130

Brake NC

Memo

0.00

Brake NC

140

Chemical Conversion Coat per QSI005 4.1

0.00

150

HandFinish

Memo

0.00

Hand Finishing

Work Order ID 80022***80022***

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N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Angle

Start Date: 2/10/2012 Start Qty: 8.00 ***8***Required Date: 2/17/2012 Req'd Qty: 8.00 ***8***

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160

~~QC3-~~ Inspect Part Finish

0.00

160

QC7

QC

Memo

0.00

Quality Control

12 X 1/2" M / 12/02/13

170

Identify as per dwg & Stock Location

0.00

170

G.A

Packaging

Memo

0.00

Packaging

12/02/14 (12)

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

12/2/17

ME
12-02-17

Picklist Print

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Page 1

Work Order ID: 80022

Parent Item: D4006-1

Parent Item Name: Angle

Start Date: 2/10/2012

Required Date: 2/17/2012

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP rev A 09.12.18 new issie Prelim EC verified by:DD IPP Rev:B 10.05.03 as per ECN10-562 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.063 2024-T3 .063 sheet		Purchased	No			100	sf	211.5000	1	8			

12-2-10
12

Location

Loc Qty

Loc Code

MAT022

211.5

117392

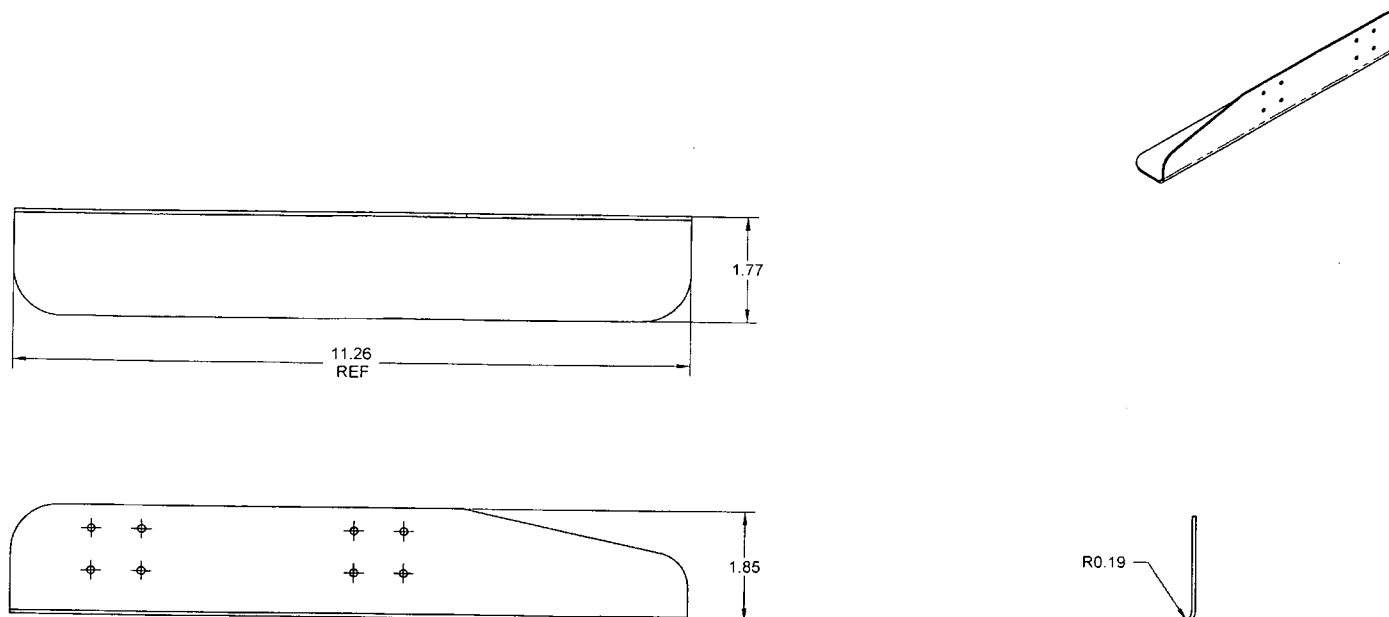
19.5

119916

192

117392

DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4006-1	REF JCA-M47-2-01



D4006-1 ANGLE

R0.19

80022
RELEASED
2010-05-05
MP

- NOTES:
- 1) MATERIAL: MADE FROM D4006-1F
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.23 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4006	SHEET 2 OF 6
APPROVED		TITLE	SCALE
DE APPR.		UPPER RESTRAINT	NTS
DATE	10.02.05	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

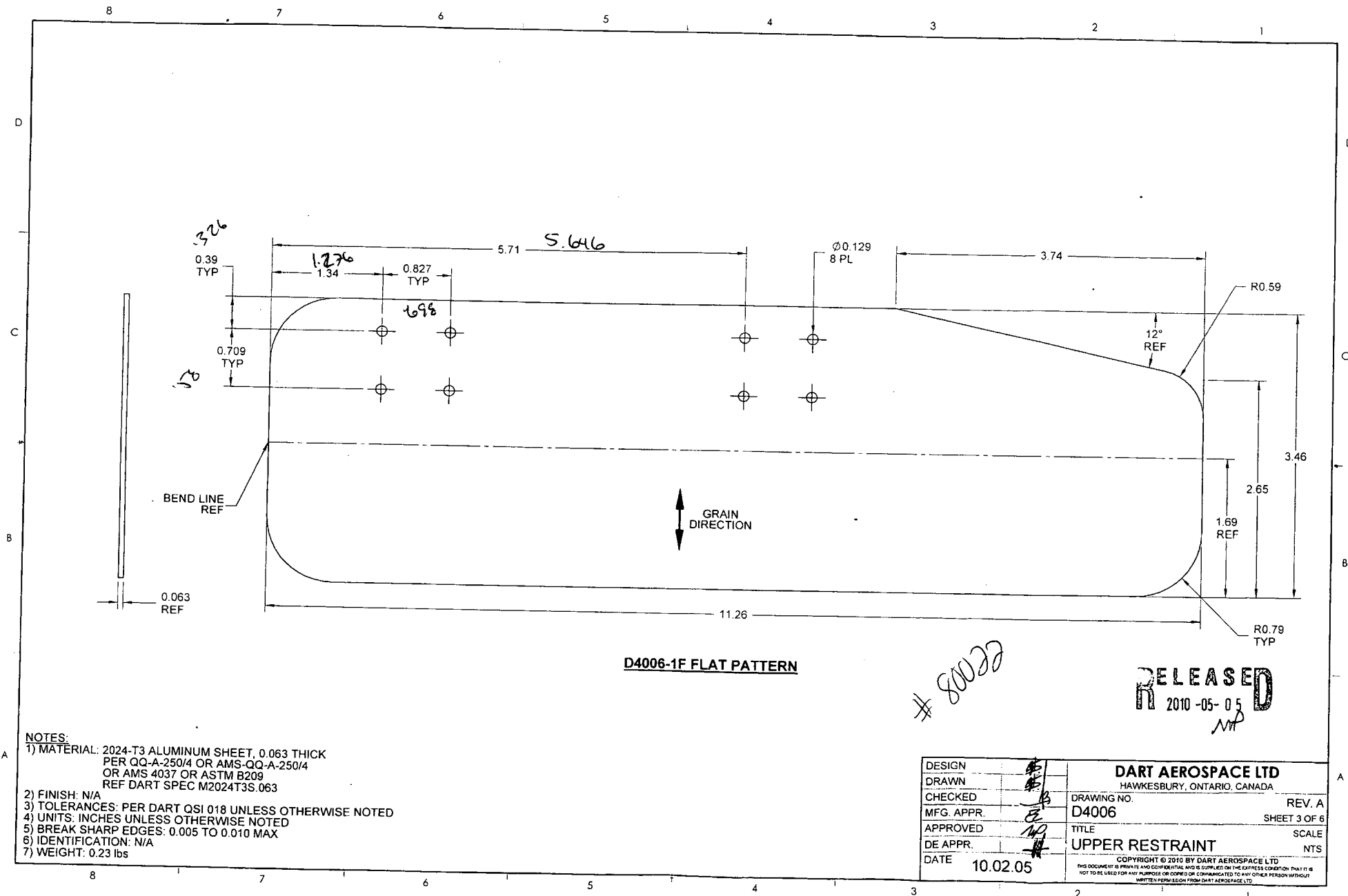
Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



W/O:		WORK ORDER CHANGES					
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